

Work Order ID 132554

132554

Page 1

May-07-15 2:56:01 PM

Item ID: D407-559-113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 206L Series/407 Bearpaws - Large

Start Date: 4/27/15 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 11 2015

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

L

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo M. D.

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPPD407-559-113 CHG003

6/9-89 2

CL 15-06-02

JUN 07 2015

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DAS
28
9-89

2x

DAS
28
9-89

JUN 02 2015

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

DAS
6
9-89

2

JUN 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

Work Order ID 132554

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May-07-15 2:56:01 PM

Page 2

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 206L Series/407 Bearpaws - Large

Stop ***NS2***

Start Date: 4/27/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	Packaging					<u>2</u>			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-559-113								
	Location: <u>F615</u>								DAS 6 9-89
190		0.00							
190	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control						<u>MCS</u>			<u>JUN 10 2015</u>

MF
15-6-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

May-07-15 2:56:00 PM

Page 1

Work Order ID: 132554

132554

Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 4/27/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD 09.10.29 verified by:EC
 IPP RevB: ECN09-698p DD 09.11.03 verified by:EC
 as per revision K DD 09.11.24 verified by:EC
 per ECN10-575 DD verf:EC
 IPP RevC: IPP Rev:D 10.05.27
 IPP REV:E 11-04-11 PER INN REV L JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 *D2274* Radius Block		Manufactured	No			160	Each	549.0000	16	32		DAS 28 9-89	JUN 02 2015
				<u>Location</u>				<u>Loc Qty</u>					
				FG				12					
				86855				12					
				ST006				402					
				127579				390		32			
				129934				12					
				ST012a				135					
				131031				135					
D3456-1 *D3456-1* Washer		Manufactured	No			160	Each	79.0000	8	16		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				FG				7		132585			
				25701				7					
				ST051A				72					
				128456				3					
				129861				19					
				130974				50					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

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Work Order ID: 132554*

Parent Item: D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

132554

D407-559-113

Start Date: 4/27/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

D4011-1

Manufactured No

160

Each

18.0000

16

D4011-1

Clamp, Short

DAS
6
9-89

Location

Loc Qty

Loc Code

ST542

18

130923

18

160

Each

8.0000

16

D4011-5

Manufactured No

D4011-5

Clamp, Short

DAS
6
9-89

Location

Loc Qty

Loc Code

ST544

8

131258

8

160

Each

16.0000

16

D4012-1

Manufactured No

D4012-1

Cushion

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

131213

5

ST545

11

131213

11

160

Each

2.0000

16

D4355-1

Manufactured No

D4355-1

Bearpaw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST470A

2

113302

1

96312

1

113302

132508 X 8
132221 X 2

DAS
28
9-89

JUN 02 2015

6x

DAS
28
9-89

132624

DAS
28
9-89

132619

#4

DAS
28
9-89

132552 X 2

1

7238721

DAS
28
9-89

Must be
Rev. C
per ECN 15.532

May-07-15 2:56:00 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Page 3

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Parent Item Name: 206L Series/407 Bearpaws - Large

132554

D407-559-113

Start Date: 4/27/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

D4360-041

Manufactured No

160 Each

6.0000 2 4

DAS
28
9-89

JUN 02 2015

D4360-041

Wearplate Assembly

DAS
6
9-89

Location

Loc Qty

Loc Code

ST608

6

102873

1

115962

5

160 Each

49.0000

16

**

DAS
28
9-89

AN4C11A

AN4C11A

bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST344

49

131677

24

m131957

25

160 Each

94.0000

16 32

**

DAS
28
9-89

AN4C20A

AN4C20A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST312A

94

129390

19

M128429

25

M128818

50

160 Each

117.0000

16 32

**

DAS
28
9-89

AN4C21A

AN4C21A

BOLT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST312A

50

M129384

50

ST342

67

M128636

17

M129390

50

15
17

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Shop Packet Print

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

May-07-15 2:56:01 PM

Page 4

Work Order ID: 132554

Parent Item: D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

132554

D407-559-113

Start Date: 4/27/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

160

Each

623.0000

24

48

DAS
28
9-89

JUN 02 2015

MS21043-4

Nut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

330

m128798

330

ST304

253

m128818

34

m131697

219

160

Each

4,471.000

16

32

DAS
28
9-89

48

NAS1149D0463J

Purchased

No

NAS1149D0463J

WASHER

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

4430

M129682

86

M130799

371

M132035

3973

132317

DAS
26
9-89

May-07-15 2:56:01 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Change Record

PAGE 1 OF 1

Part Number: D407-559-113

Description: BEARPAW INSTALLATION

[illegible]

DAS
6
9-89

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REFERENCE ONLY

D206-559
Page 7 of 13

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X						✓	D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1J	CLAMP, SHORT
						8	D4011-5J	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1J	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS11749D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: L
Date: 11.04.08